

Work Order ID 82334

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82334

Page 1

Item ID: D2528-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Backer Plate
 Start Date: 28/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12/03/29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2528	Rev C1					(X)			

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2528 Dwg Rev: C1 Prog Rev: C1 2-
 Deburr if necessary
505-063 B12-5-30

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control B12-5-30

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 Scz10731 cutted
 Quality Control (726)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									

2674612-5-31

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:45</u> OVEN TEMPERATURE:								
	FINISH TIME: <u>11:15</u>								

26X 12/06/01

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

26 BR 26-1.

W 21134

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Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 28/03/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 11/04/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

Identify as per dwg & Stock Location: 010

0.00

160

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/6/4 ~~AD~~

MLW 12/06/07

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Picklist Print

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Page 1

Work Order ID: 82334

82334

Parent Item: D2528-1

D2528-1

Parent Item Name: Backer Plate

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.06.26Removed P/O for powder coatEC
IPP Rev:D 08-07-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063

Purchased

No

100

sf

76.8526

0.0303

0.318947

1.

M5052H32S 063

**

B12-G-30

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

76.852632

114322

12.852632

120603

64

120603



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DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

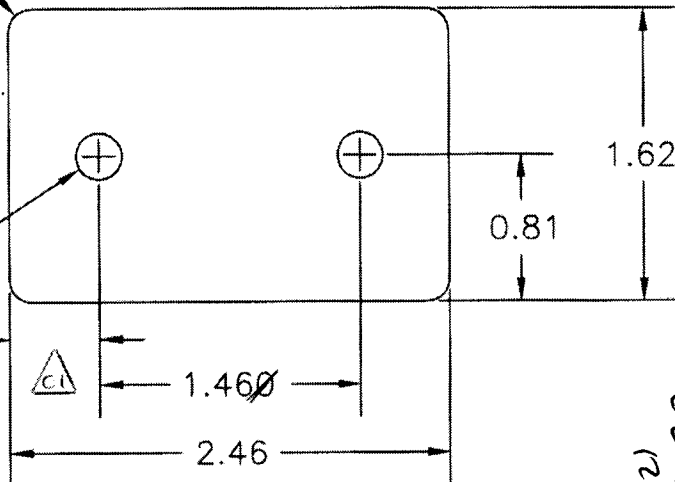
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW
[Signature]
01/03/03

Ø0.257 (TYP)

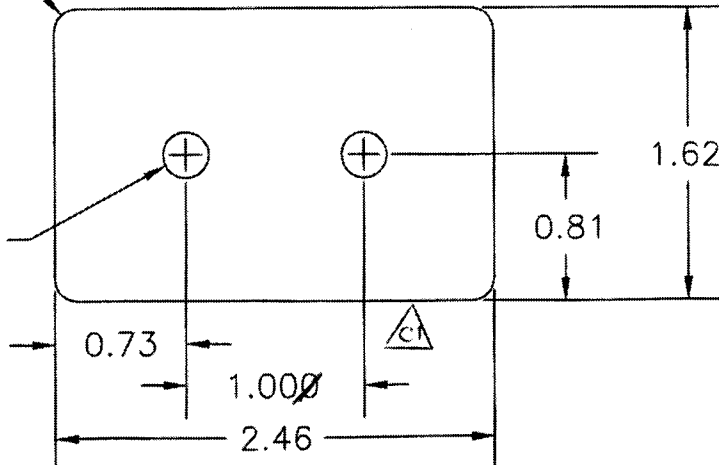
0.50



D2528-1

R0.13 (TYP)

Ø0.257 (TYP)



D2528-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82334
12/03/04 *MC*

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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